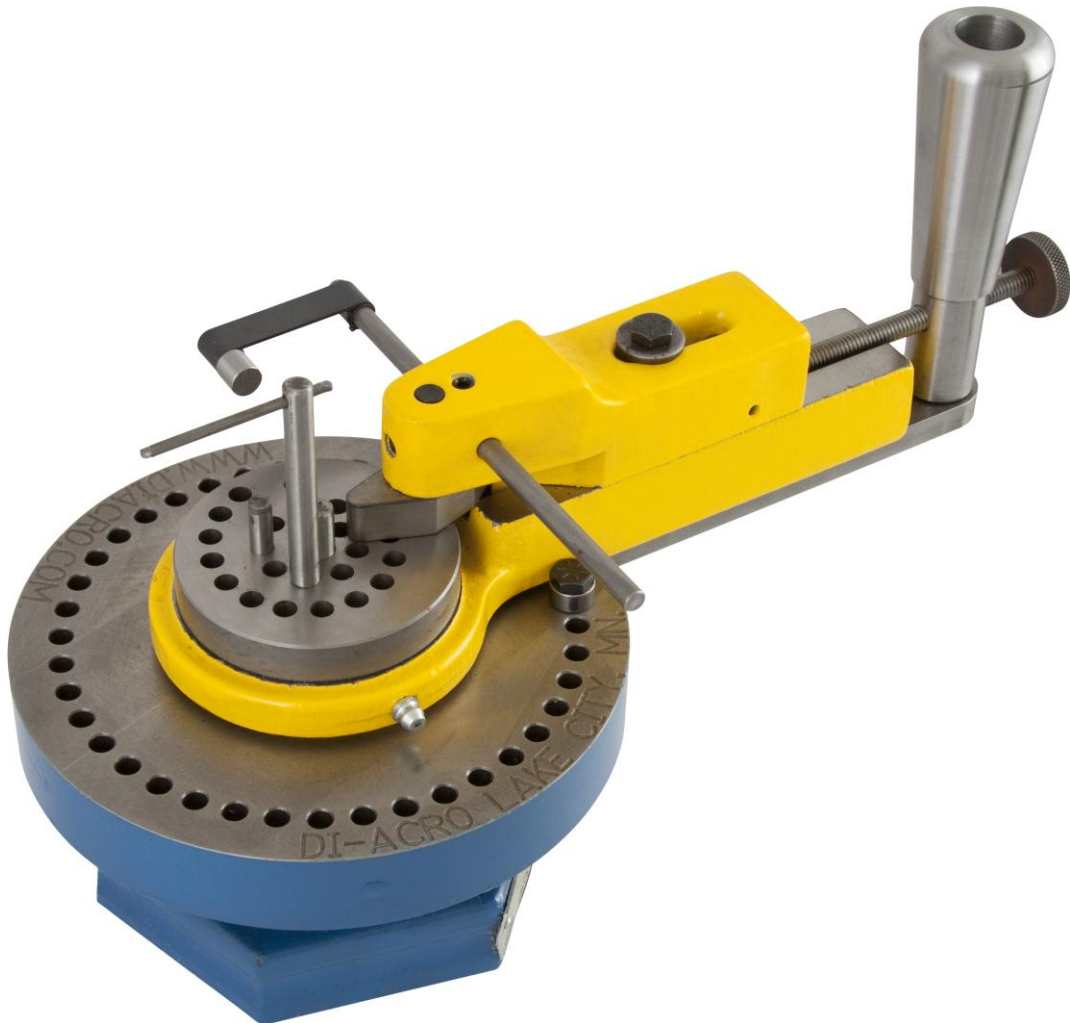


DI-ACRO

#1 HAND BENDER

INSTRUCTION MANUAL



ACROTECH  **DI-ACRO**

Manufacturers of **K-Prene®**... the unequalled **Urethane**

Metal Fabrication Equipment

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TABLE OF CONTENTS

A.	SAFETY INFORMATION	PG. 3
B.	MAINTENANCE	PG. 3
C.	#1 HAND BENDER PARTS LIST	PG. 4-5
D.	QUIK LOCK PARTS LIST	PG. 6
E.	SPECIFICATIONS & THE ART OF BENDING	PG. 7
F.	OPTIONAL STAND	PG. 8
G.	BENDER TOOLING	PG. 9-10
H.	WARRANTY	PG. 11

A. Safety Instructions



Before bender is set up for operation, mount on work bench or stand* with stand or work bench bolted in place.

***IF BENDER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR**

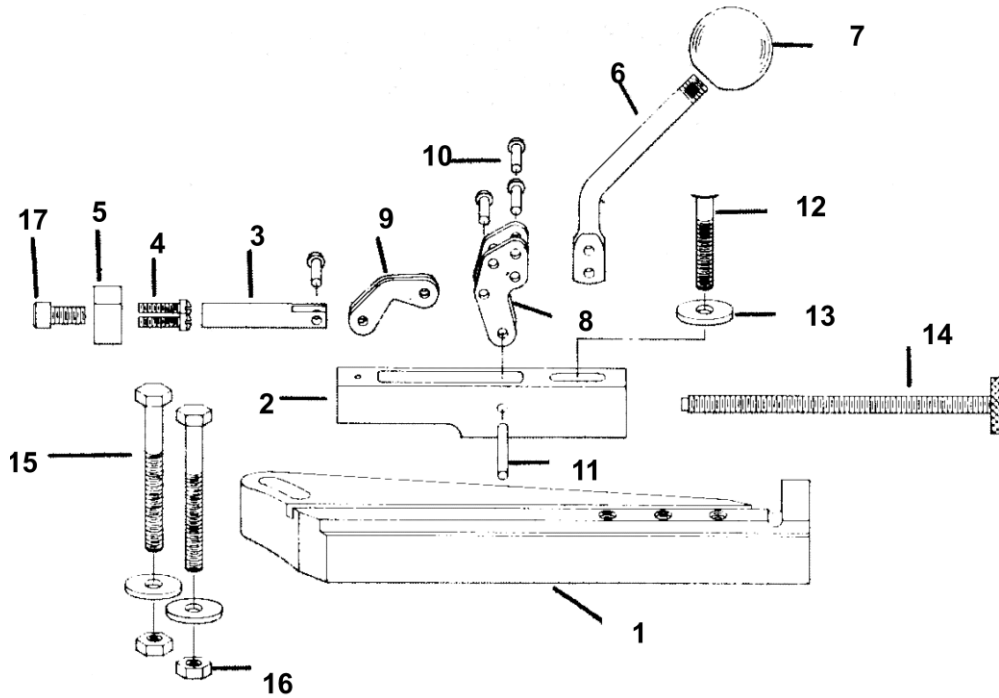
B. Maintenance

Add grease in grease zerker periodically.

PARTS LIST
#1 HAND BENDER
8100800-080

ITEM	PART NUMBER	DESCRIPTION	QTY
1	100-1101001	BASE	1
2	100-1208002	PADDLE	1
5	8690100-200	GREASE FITTING	1
6	100-1208005	HANDLE ARM	1
7	21A0104F0304	SCREW-HEX HD 1/ 4-28X3/4	2
8	30X0308C	NUT-FULL 3/8-16	1
9	100-4701007	HANDLE STUD	1
10	8120811-400	REVOLVING HANDLE	1
13	100-1217023	SUPPORT SCREW ASSEMBLY	1
14	31X0516C	NUT-JAM 5/16-18	1
15	100-1105011	MOUNTING PLATE	1
16	3103001	NEEDLE BEARING	57
17	100-5702038	SHIM	6
18	19A0104C0304	DOWEL PIN 1/4 X 3/4	2
19	21A0516C1000	SCREW-HEX HD 5/16-18X1	2
20	100-1217015	NOSE HOLDER	1
21	100-5104014	NOSE SPRING	1
22	20BX104C0308	SCREW-BUT HD 1/4-20X3/8	1
23	21A0104F2000	SCREW-HEX HD 1 /4-28X2	1
24	0104WILLIAMS WASHER	WILLIAMS WASHER 1/4	1
25	23A0104C0308	SCREW-SOC SET 1/4-20X3/8	1
26	19A0516X1102	DOWEL PIN 5/16 X 1-1/2	1
27	100-1217013	FORMING NOSE	1
28		BEND LOCATING GAUGE(SEE BELOW)	
	100-1420033	BEND LOCATING GAUGE ROD	1
	100-1420034	BEND LOCATING GAUGE ARM	1
	100-1420035	BEND LOCATING STOP BUTTON	1
	8470510-900	RETAINING RING	2
32	8100006-970	RADIUS PIN	1
33	100-1203029	LOCKING PIN "A"	1
34	100-1203028	LOCKING PIN	1
35	100-1203037	HOLDING PIN	1
36	100-1410019	RETURN STOP	1
37	100-1420018	ANGLE GAUGE	1
38	21A0104C1102	SCREW-HEX HD 1 /4-20X1-1/2	2
39	31X0104C	NUT-JAM 1 /4-20	2

**PARTS BREAKDOWN
#1 HAND BENDER QUIK LOK ASSEMBLY
106-1113801**



**PARTS LIST
#1 BENDER QUIK LOK ASSEMBLY**

ITEM	PART NUMBER	DESCRIPTION	QTY
1	106-1113001	BASE	1
2	8116111-302	HANGER A	1
3	8000111-300	SLIDE ARM	1
4	21AXX10F0308	SCREW-HEX HEAD #10-24X3/8	2
5	8100111-300	NOSE	1
6	8200111-300	HANDLE ARM	1
7	8120810-600	PLASTIC KNOB	1
8	8111312-400	HANDLE LINK	2
9	8111312-500	LINK	1
10	8470310-100	RIVET	4
11	19A0316X1104	DOWEL PIN 3/16X1-1/4	1
12	21A0104C1304	SCREW-HEX HD 1/4-20X1-3/4	1
13	0104WILLIAMS WASHER	WASHER-WILLIAMS 1/4	3
14	100-1217023	SUPPORT SCREW ASSEMBLY	1
15	21A0104C2102	SCREW-HEX HD 1/4-20X2-1/2	2
16	30X0104C	NUT-FULL 1/4-20	2
17	20A0516C0508	SCREW-SOC HD 5/16-18X5/8	1

- E. We are proud to re-introduce the #1 Bender, which we affectionately call “Junior.” Although, the #1 Bender is the “midget” of the Di-Acro Bender family, this precision machine is a high-speed production unit for all materials within its range. Small parts can often be formed at rates in excess of 750 bends per hour.

SPECIFICATIONS

Radius Capacity	2"
Height of Standard Forming Nose	1 1/2"
Built-Up Nose	1"
Center Hole Diameter	3/8"
Operating Leverage	8"
Weight	22 lbs.
Material Capabilities	
Round Mild Steel Bar	3/16"
Square Mild Steel	1/8"
Steel Tubing	5/16"
Flat Steel Bar (Easy Way)	1/8" x 3/4"
Flat Steel Bar (Hard Way)	1/16" x 1/2"
Angle	1/16" x 1/2" x 1/2"
Channel	1/16" x 1/4" x 1/2"



FOR A COMPLETE DESCRIPTION OF 20 BENDING OPERATIONS WITH CLEAR STEP-BY-STEP ILLUSTRATIONS OF EACH, REFER TO THE DI-ACRO “**ART OF BENDING**” CATALOG THAT WAS INCLUDED WITH THIS CATALOG. IT SHOWS OVER 90 DIAGRAMS AND CHARTS TOGETHER WITH VALUABLE TOOLING SUGGESTIONS.

- F. OPTIONAL STAND PART NUMBER 8230110-900
 STAND DIMENSIONS ARE:
 20" WIDE, 15" DEEP, 33-1/4" HIGH








CALL ACROTECH FOR PRICE AND AVAILABILITY





Fasteners needed to attach Hand Bender to stand are the following:
 Fasteners to attach stand to floor are not included

PART NUMBER	DESCRIPTION	QTY
21A0102C2102	Screw-HHCS 1/2-20X2	3
61X0102	Washer-Flat 1/2	3
31X0102	Nut-Hex Jam 1/2-20	3

#1 BENDER TOOLING

DESCRIPTION	PART NUMBER	SIZE	
BUILT-UP FORMING NOSE 	8100250-000	1" HT	
FORMING ROLLER 	8100690-000	1-1/4" DIA	
RADIUS BLOCK 	8100000-920	ZERO	
	8100001-920	1/32" R	
	8100002-920	1/16" R	
	8100003-920	3/32" R	
	8100002-970	1/16" R	
 RADIUS PIN	8100003-970	3/32" R	
	8100004-970	1/8" R	
	8100005-970	5/32" R	
	8100006-970	3/16" R	
	8100007-970	7/32" R	
	8100008-970	1/4" R	
	8100010-970	5/16" R	
	8100012-970	3/8" R	
	8100014-970	7/16" R	
	 RADIUS COLLAR	8100016-930	1/2" R
8100018-930		9/16" R	
8100020-930		5/8" R	
8100022-930		11/16" R	
8100024-930		3/4" R	
8100026-930		13/16" R	
8100028-930		7/8" R	
8100030-930		15/16" R	
8100100-930		1" R	
 GROOVED FORMING ROLLER			
	8100004-790	1/8"	
	8100006-790	3/16"	
	8100008-790	1/4"	
	8100010-790	5/16"	
	8100012-790	3/8"	
 FOLLOW BLOCK			LENGTH TUBE DIA
	8106004-620	3"	1/8"
	8106005-620	6"	1/8"
	8106006-006	3"	3/16"
	8106007-620	6"	3/16"
	8106008-620	3"	1/4"
	8106009-620	6"	1/4"
	8106010-620	3"	5/16"
	8106011-620	6"	5/16"
8106012-620	6"	3/8"	

#1 BENDER TOOLING			
DESCRIPTION	PART NUMBER	SIZE	C/L RADIUS
 <p>CLAMP BLOCK (USE WITH QUIK-LOK CLAMP)</p>		TUBE DIA.	
	8106004-320	1/8"	
	8106006-320	3/16"	
	8106008-320	1/4"	
	8106010-320	5/16"	
	8106012-320	3/8"	
 <p>RADIUS COLLAR "A" STYLE (USE WITH QUIK-LOK CLAMP)</p>	8106012-004	1/8"	3/8"
	8106024-004	1/8"	3/4"
	8106100-004	1/8"	1"
	8106016-006	3/16"	1/2"
	8106024-006	3/16"	3/4"
	8106100-006	3/16"	1"
	8106020-008	1/4"	5/8"
	8106100-008	1/4"	1"
	8106024-010	5/16"	3/4"
	8106100-010	5/16"	1"
	8106108-010	5/16"	1-1/4"
	8106100-012	3/8"	1"
	8106108-012	3/8"	1-1/4"

Warranty & Limitation of Liability

Defective parts of a product manufactured by ACROTECH/DI-ACRO will be replaced or repaired at no charge for twelve (12) months following delivery to the original purchaser. Labor is included for the first 90 days. This warranty becomes void when products have not been used according to instructions furnished by ACROTECH/DI-ACRO, nor does it cover any altered parts or unauthorized repairs. We cannot be responsible for the cost of repairs made or attempted outside of our factory. All warranty claims are made FOB our plant, providing such item(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components or systems not manufactured by ACROTECH/DI-ACRO. These products are covered instead by the existing warranties, if any, of their manufacturers. Normal service items with a reasonable life expectancy of less than one year are warranted only to the extent of the reasonable life under normal use and service.

Authorization must be obtained from ACROTECH/DI-ACRO before returning parts or equipment to the factory. ACROTECH/DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt and inspection of the product.

ACROTECH/DI-ACRO's liability under this warranty shall not exceed the amount paid for the product.

THIS IS ACROTECH/DI-ACRO'S SOLE WARRANTY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY, FITNESS OR ANY LOSS, DAMAGE OR EXPENSES DIRECTLY OR INDIRECTLY RELATED TO THE USE OF ITS PRODUCT OR FROM ANY OTHER CAUSE OR FOR CONSEQUENTIAL DAMAGES INCLUDING, WITHOUT LIMITATION, LOSS OF TIME AND LOSS OF PRODUCTION.

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